

Work Order ID 50389

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Item ID: D3151-1	Accept		Setup Start	
Revision ID: C			Stop	
Item Name: Bracket Flat Pattern				
Start Date: 7/15/09	Start Qty: 6.00		Cust Item ID:	
Required Date: 7/15/09	Req'd Qty: 6.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>MF</u>	Date: <u>09-07-15</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3151	Rev C								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3151 <input type="checkbox"/> Dwg Rev: <u>C</u> <input type="checkbox"/> Prog Rev: <u>C</u> <input type="checkbox"/> 2- Deburr if necessary								

HB 9-8-13

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

HB 9-8-13

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									






=> 8/2/09/13



(45)




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Required Date:	7/15/09	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							Q.P. 09-08-14 (9)
170  Packaging Packaging	Identify as per dwg & Stock Location (68) Memo	0.00 0.00							9/8/14 (9x) Sp
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							09/08/14 JF mf 09-08-17

Picklist Print

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Parent Item: D3151-1RevC



Parent Item Name: Bracket Flat Pattern

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	77.9100	0.5432	9		



2024-T3 .040 sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

77.91

110337

6.4

111381

4

111786

67.51

111786

13 9-8-13

9

D3065-5DART AEROSPACE LTD		Work Order:	50389
Description: Doubler Assembly		Part Number:	D3151-1
Inspection Dwg: D3151	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.099	*			
Ø0.250	+0.005/-0.001	.250	*			
Ø0.700	+0.008/-0.001	.701	*			
4.50	+/-0.030	4.503	*			
2.75	+/-0.030	2.746	*			
0.688	+/-0.010	.686	*			
0.344	+/-0.010	.345	*			
1.075	+/-0.010	1.076	*			
2.150	+/-0.010	2.151	*			
3.800	+/-0.010	3.802	*			
1.975	+/-0.010	1.972	*			
0.350	+/-0.010	.351	*			
2.050	+/-0.010	2.049	*			
1.375	+/-0.010	1.377	*			
0.350	+/-0.010	.350	*			

Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 9-8-13	Date: 08/05/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.20	New Issue	KJ/DD	

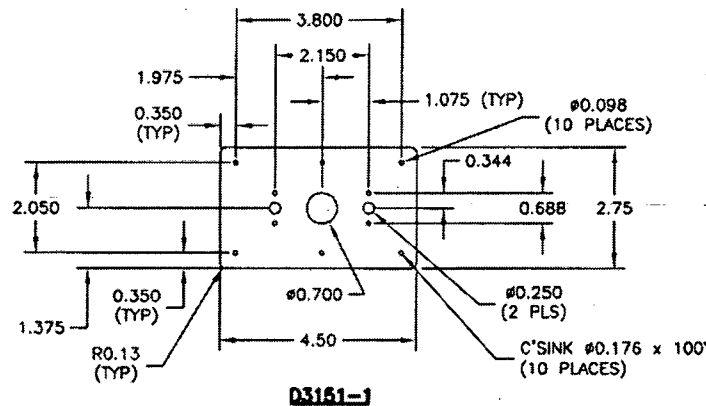
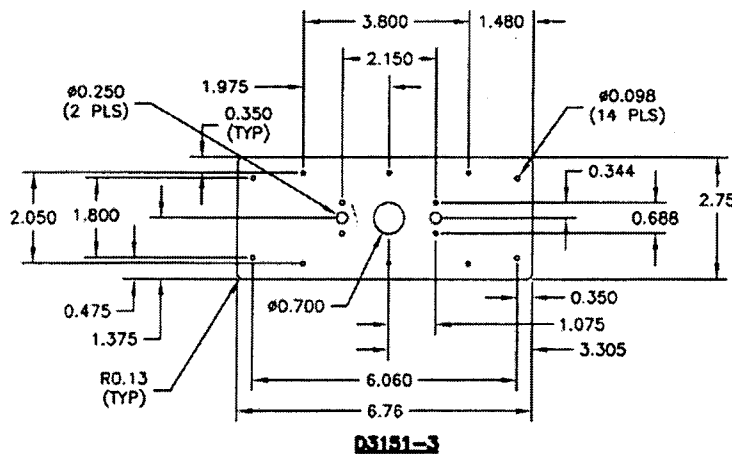
DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3151	REV. C SHEET 1 OF 1
DATE 05.12.07		TITLE DOUBLER ASSEMBLY	SCALE 1:4
A	02.04.23	NEW ISSUE	
B	04.09.08	RE-DESIGN	
C	05.12.07	REVISE NOTES	

MS20426AD3-3 RIVET (1)
(6 PLACES)MS21059L08 NUTPLATE (1)
MS20426AD3-4 RIVET (2)
(2 PLACES)

D3151-3

D3151-1

D3151-041 DOUBLER ASSEMBLY
REPLACES PREMIER P/N B30-23000-173/-174**RELEASED**05.12.07 *[Signature]***D3151-1****D3151-3**SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50389

mf 09-07-15

NOTES

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.040" THICK (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N D3151-041 USING FINE POINT PERMANENT INK MARKER

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